Work	Ore	ler ID	63938
WUIK	vit	161 117	しいている

Quality Control

Friday, November 19, 2010 1:02:04 PM



Page 1

1B10-11-09

Item ID: D4006-3 Accept Setup Start **Revision ID:** Stop Item Name: Channel Start Date: 11/19/2010 Start Oty: 8.00 **Cust Item ID: Required Date:** 11/30/2010 Reg'd Otv: 8.00 Customer: Reference: Run Start Process Plan: MF Date: 10-11-19 Approvals: Tooling: Date: Stop OC: Date: SPC (Y/N): Date: Sequence ID/ Operation Set Up/ Tool ID Tool # Plan Accept Reject Reject Insp. **Work Center 1D** Description **Run Hours** Code Qty Qty Number Stamp Draw Nbr Revision Nbr D4006 Α 100 0.00 1B10-11-29 Wateriet 0.00 Memo FLOW CNC Wateriet 1-Cut as per Dwg Dwg Rev: 200. 4605 Prog Rev: 2-Deburr if necessary 110 QC2- Inspect parts off machine FAI/FAIB 0.00

0.00

Memo

W/O:			WC	RK ORDER CHANGE	S			
DATE	STEP	PR	OCEDURE CHA	NGE	Ву	Date Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
						,		
				PART 14				
Part No	:	PAR #:	Fault Cate	gory:	NCR: Yes	No DQA:	Date: _	
		esolution:						
NCR:			WORK ORDI	ER NON-CONFORMAI	NCE (NCR)		
DATE	STEP	Description of NC	Description of NC Corrective Action Section			Verification	Approval	Approval
DATE	SIEF	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Chief Eng	QC Inspector

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- Work Order ID 63938

Friday, November 19, 2010 1:02:04 PM



Page 2

Item ID:

D4006-3

Accept

Setup Start



Revision ID:

Item Name: Channel

Start Date:

11/19/2010

Start Oty: 8.00

Required Date: 11/30/2010 Reg'd Oty: 8.00



Cust Item ID:

Customer:

Reference:

Approvals:

QC:

Process Plan: Date:

Date:

Tooling: SPC (Y/N):

Date:

Date:

Run

Start Stop

Stop



Sequence ID/

Work Center ID

120

OC

Quality Control

Operation Description

OC8- Inspect parts - second check

Memo

Set Up/

Run Hours

0.00

00/ NOID 8 00.0

SB (0/12/1

Tool ID

Plan Tool# Code

Accept **Qty**

Reject Qty

Reject Number

Insp. Stamp

Brake NC

130

Brake NC

Bend as per dwg

C'sink as per dwg

Hand Finishing

Chemical Conversion Coat per QSI005 4.1

M 10/12/02

150

HandFinish

Memo

0.00

W/O:			ES							
DATE	STEP	PRO	CEDURE CH	ANGE	Ву	D	ate	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No: PAR #:			Fault Ca	tegory:	NCR: Ye	s No	DQA:		_ Date: _	
			Disposit	QA: N/C	A: N/C Closed: Date:					
NCR:		V	VORK ORI	DER NON-CONFORMA	NCE (NC	R)	,	•		
DATE	CTED	Description of NC		Corrective Action Section B			Verificat	tion	Approval	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sigr Da	1 &	Section		Chief Eng	QC Inspector
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- Work Order ID 63938

Friday, November 19, 2010 1:02:04 PM



Page 3

Item ID:

D4006-3

Accept

Setup Start

Stop



Revision ID:

Item Name: **Start Date:**

Channel

11/19/2010 Start Qty: 8.00

Required Date: 11/30/2010

Reg'd Qty: 8.00



Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan: Date:

Tooling:

Date:

Run Start



QC:

Date:_____

SPC (Y/N):

Date:

Stop



Sequence ID/

Work Center ID

160

QC

Operation Description

QC5- Inspect part completeness to step on W/O

Set Up/ **Run Hours**

Tool # Plan Code

Accept Qty

Reject Oty

Reject Number

Insp. Stamp

Quality Control

0.00

Tool ID

170

Packaging

Packaging

Identify as per dwg & Stock Location: 1/0

Memo

Memo

0.00

0.00

180

Quality Control

QC

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

10/12/0348) PS 10-12-02

W/O:		WORK ORDER CHANGES									
DATE	STEP	PRO	OCEDURE CH	ANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector		
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Part No	•	PAR #:	Fault Cate	egory:	NCR: Yes	No DQ	A:	Date:			
				isposition: QA: N/C Clo			Closed: Date:				
NCR:		\	WORK ORE	ER NON-CONFORMA	NCE (NC	R)					
	1	 			Verification						
DATE	STED	Description of NC				Verific	cation	Approval	Approval		
DATE	STEP	Description of NC Section A	Initial Chief Eng	Corrective Action Section Action Description Chief Eng	n B Sign Date	& Secti	cation ion C	Approval Chief Eng	Approval QC Inspector		
DATE	STEP	Description of NC Section A		Action Description	Sign	& Secti					
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Picklist Print

Friday, November 19, 2010 1:02:03 PM

Work Order ID: 63938

Parent Item:

D4006-3

Parent Item Name: Channel

Start Date: 11/19/2010

Required Date: 11/30/2010

Page 1

Start Qty: 8.00

Required Oty: 8.00

Comments:

IPP rev A 09.12.22 new Issue Prelim EC verified by:DD 10.05.03 as per ECN10-562 DD verified by:EC

IPP Rev:B

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M2024T3S.063		Purchased	No			100	sf	81.3100	0.0971	0.817684			**
2024-T3 .063 sheet											HB 10-1	1-29	

<u>Location</u>	Loc Qty	Loc Code		
MAT22	81.31			$\langle x \rangle$
113866	0.81		113866	(4)
114351	80.5			

W/O:			WC	RK ORDER CHANGE	S						
DATE	STEP	PRO	OCEDURE CHA	NGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector		
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				.*							
Part No		PAR #:	Fault Cate	gory:	NCR: Yes	No DQA :	:	_ Date: _			
	Resolution: Disposition: QA					A: N/C Closed: Date:					
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DATE	STEP	Description of NC		Corrective Action Section		Verifica		Approval	Approval		
	O L	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section	ı C	Chief Eng	QC Inspector		
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DART AEROSPACE LTD	Work Order: 63938 (
Description: CHANNEL	Part Number: \$\\\406-3
Inspection Dwg: 54%-3, Rev: A	Page 1 of 1

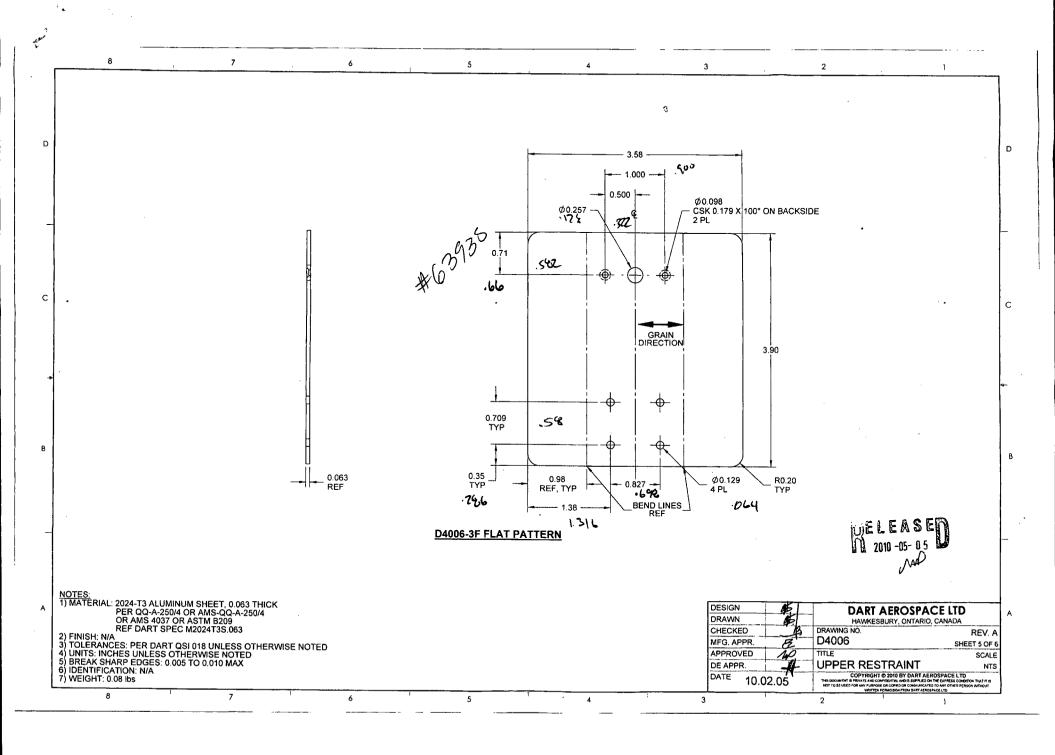
FIRST ARTICLE INSPECTION CHECKLIST

X First Article X Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Rejest	Method of Inspection	Comments
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1.000	th 010	,999	2		V	
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3,90	4 .30	3,907	W		V	
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Measured by:	51	Audited by:	Prototype Approval:	
measured by:	<u> </u>		Date:	
Date:	10-11-29	Date: U U 30		

	Doto :	Change	Revised by	Approved
Rev	Date	Change	KJ/JLM	
Α		New Issue	10002	L



W/O:		·	V	ORK ORDER CHANGE	ES					
DATE	STEP	PROC	CEDURE CHANGE				Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No	:	PAR #:	_ Fault Ca	tegory:	NCR: Y	es No	DQ.	\ :	Date:	
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DATE	STEP	Description of NC			on B		Verific	ation	Approval	Approval
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2 DART AEROSPACE PART NUMBER JOHN CAMERON AVIATION PART NUMBER D4006-3 REF.ICA-M47-2-01 D D R0.19 TYP - 1.77 -- 1.06 --- C 3.90 REF Ф-+ Φ-# 63938 **D4006-3 CHANNEL** DESIGN DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA NOTES:
1) MATERIAL: MADE FROM D4006-3F
2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
7) WEIGHT: 0.08 lbs DRAWN DRAWING NO. CHECKED REV. A D4006 MFG. APPR. SHEET 4 OF 6 TITLE APPROVED UPPER RESTRAINT

NTS

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THIS OCCUMENT A PROMOTE VIEW AND B SUFFLAG OF THE COPYRIGHT OF ANY THAT OF THE COPY OF T DE APPR. DATE 10.02.05 8 7 5 3 2

W/O:			V	ORK ORDER CHANGI	ES			
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Part No:		PAR #:	Fault Ca	tegory:	NCR: Yes	No DQA: _	Date: _	
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DATE	STEP	Description of NC Section A			on B	Verificati		Approval
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[;] NOTE: Date & initial all entries

HAMFORMS\Quality Assurance\approved QA\NCRWO RevE